

# Work Order ID 60930

July 27, 2010 8:36:43 AM



Page 1

Item ID: D2195-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 7/27/10 Start Qty: 4.00



Cust Item ID:

Required Date: 7/30/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2195

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2195 ☒ Dwg Rev: D ☐ Prog Rev: D ☐ 2-  
Deburr if necessary

6061 .5 x 5,

HB 10-7-28

*JS 10/07/28*

(S)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 10-7-28

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*S 10/07/28*

(45)

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Page 2

Item ID: D2195-3

Accept



Setup Start



Revision ID:

Item Name: Spacer

Stop



Start Date: 7/27/10

Start Qty: 4.00



Cust Item ID:

Required Date: 7/30/10

Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-open hole to finish size as per dwg 2- deburr

*JS 07/28* (5)

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*Siobhán*

(X5)

150

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

*BT 10.07.20* (X5)

# Work Order ID 60930

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Item ID: D2195-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 7/27/10

Start Qty: 4.00



Cust Item ID:

Required Date: 7/30/10

Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

⇒ 90

10/07/28

5 9

170

Identify as per dwg & Stock Location: 008

0.00



Packaging

Memo

0.00

Packaging

10/07/28 (5)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/29  
pl 10-728 (5)

# Picklist Print

July 27, 2010 8:36:42 AM

Page 1

Work Order ID: 60930

Parent Item: D2195-3

Parent Item Name: Spacer



Start Date: 7/27/10

Required Date: 7/30/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-07-24 new issue ec verified by:dd  
IPP Rev:B 09-01-28 rev.d as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X05.00 0		Purchased	No			100	f	51.6636	0.351	1.477895	1.8		

6061-T6 Bar .500 x 5.00

Location

Loc Qty

Loc Code

MAT03

51.6636

112041

20

112154

31.6636



1810-7-28

(5)

112154

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D2195	BRACKET ASSEMBLY
7	1	D2195-1	BRACKET
8	1	D2195-2	BRACKET
9	1	D2195-3	SPACER
15	6	MS20470AD4-14	RIVET

RELEASED  
09/01/13

**NOTES:**

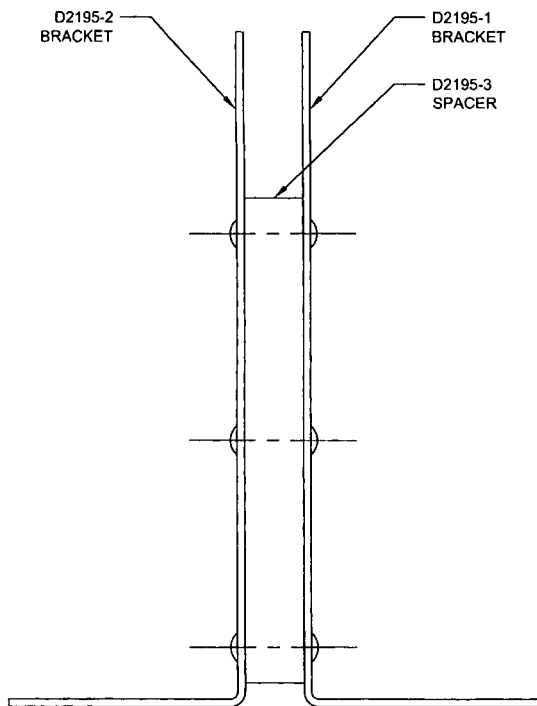
- 1) MATERIAL:
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2195" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.26 lbs

D	RE-DESIGN. REF NCR 08-110.	AJS	08.11.25
C	REDRAW: D2195-3 NOW 0.5" THICK	CP	03.05.28
B	RE-DESIGN	JB	93.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JB	DRAWING NO.	REV. D
MFG. APPR.	JB	D2195	SHEET 1 OF 3
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	BRACKET	NTS
DATE	08.11.25	<small>COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

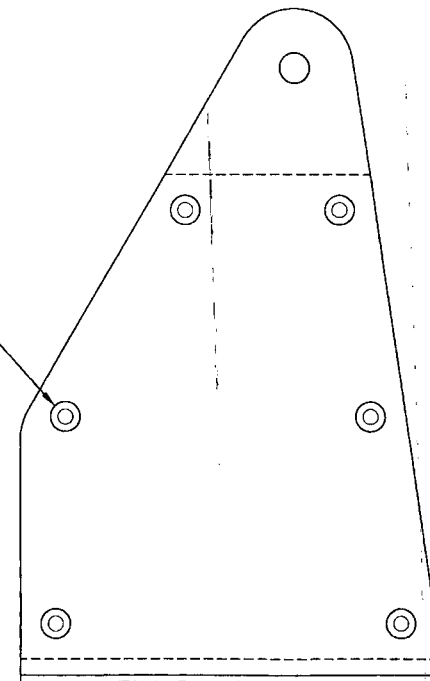
D  
C  
B  
A

D  
C  
B  
A



**D2195 BRACKET ASSEMBLY**

MS20470AD4-14  
RIVET  
6 PL



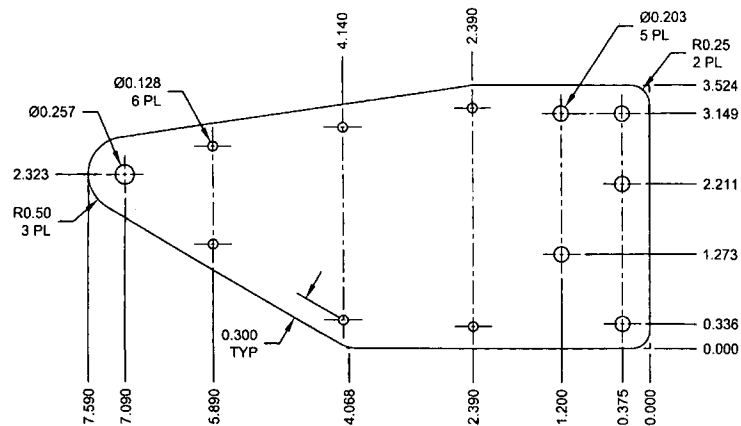
**RELEASED**  
27/01/15

*celb 60930*

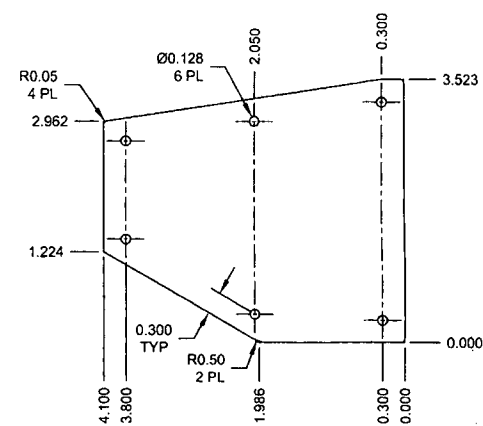
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
CHECKED	✓	DRAWING NO.	REV. D
MFG. APPR.	✓	D2195	SHEET 2 OF 3
APPROVED	✓	TITLE	SCALE
DE APPR.	✓	BRACKET	NTS
DATE	08.11.25	<small>COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

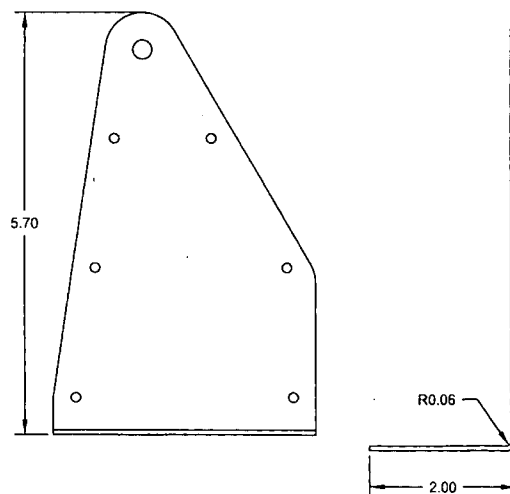




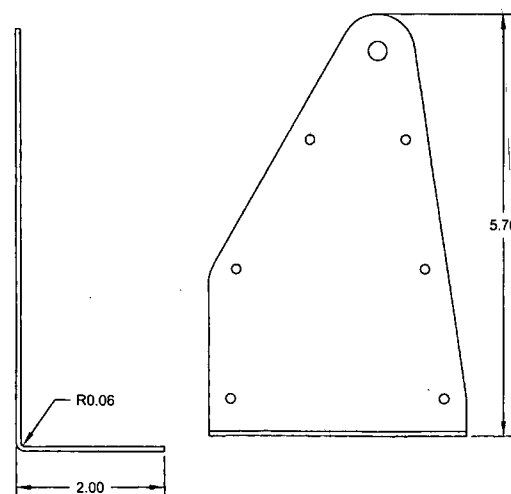
**D2195-1F BRACKET FLAT PATTERN**



**D2195-3 SPACER**



**D2195-2 BRACKET**  
MAKE FROM D2195-1F



**D2195-1 BRACKET**  
MAKE FROM D2195-1F

**NOTES:**

- 1) MATERIAL: -1 & -2: AISI 304/316 S.S. SHEET, 0.064 THICK  
PER AMS 5513 OR AMS 5524  
REF. DART SPEC M304S
- 3: 5052-H32 ALUMINUM SHEET, 0.500 THICK  
PER AMS-QQ-A-250/8 OR AMS 4016  
REF. DART SPEC M5052H32S.500
- 2) FINISH: -3 ONLY: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHT

**RELEASED**  
07/01/15

DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JS	DRAWING NO.	REV. D
MFG. APPR.	JS	D2195	SHEET 3 OF 3
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BRACKET	NTS
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